



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4635-141
Job Sheet 167079-L



Part No: D4635-141

Job Qty: 1 ea

Part Name: Fwd Ceiling Replacement Panel Assembly, LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/24/17

Job Tracking No:

Due Date: 11/10/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea		11/9/17	0.00	0.00	Start up container	D.M.L 18-1-22
100	HandThermo	1 pcs		11/9/17	0.00	1.65	HandFinish4	
110	Small Fab	1 pcs		11/10/17	0.00	1.47	Small Fab	D.B.L
120	QC	1 pcs		11/10/17	0.00	0.00	QC5	SAD 18-01-22
130	Packaging	1 pcs		11/10/17	0.00	0.00	Packaging3	D.B.L 18-1-23
140	QC21-SA	1 Ea		11/10/17	0.00	0.00	QC21	

Part Op 100 - Pick Kit

Descriptions: 110 - Assemble as per Dwg D4635-141 Bond foam core to inside of panel 3M Scotch Weld 1300

Batch: _____ 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # _____ Expiry Date _____ 3- Apply labels as per Dwg. and seal with 3M

3950 edge sealer(see note 9) Batch: _____

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D4635-1 5024905	1	1	0	0
	D4669-1 5009911	2	27	0	0
	D4695-041 5021333	1	0	0	0
	D4732-29 F123214	1	5	0	0
	D4732-33 5009002	1	4	0	0
	D4732-5 5008986	1	5	0	0
	D4732-9 5008988	1	3	0	0
	D5022-1 5034014	1	4	0	0
	MPNY-750S-9-C FA1304237		570	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Wo _____ Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com Dat: _____ DART AEROSPACE S034338 Fwd Ceiling Replacement Panel Assembly, LH PART NO: D4635-141 Original Serial #: S034338 Revision: Operation: Start up Operation 01/22/18 Change No: Job No: 167079-L Int: _____ Tr: _____ LOA _____ Substation _____ Past Expiry Date _____ Misidentified _____ Product Improvement _____ Process Improvement _____ Manufacturing Process _____ Past Due _____ Wave/Twist in Tube _____ Marks/Chatter _____ OTHER : _____	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <th colspan="4" style="text-align: center;">AGAINST DEPARTMENT/PROCESS</th> </tr> <tr> <td style="width: 15%;"> Mark _____ ap _____ -is _____ ed _____ </td> <td style="width: 15%;"> Skid-tube _____ Machining _____ Thermoforming _____ Large Fab _____ </td> <td style="width: 15%;"> Cross tube _____ Small Fab _____ Finishing _____ Composite _____ </td> <td style="width: 15%;"> Water Jet _____ Prod. Eng. Coord. _____ Rec/Store/Packaging Supplier _____ </td> </tr> <tr> <td colspan="3"> Engineering _____ Quality _____ Other _____ </td> <td></td> </tr> <tr> <td colspan="3"> QTY Effective : _____ </td> <td> MRB (QS1042) Approval _____ </td> </tr> <tr> <td colspan="3" style="height: 150px; vertical-align: top;"> Disposition </td> <td> Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____ </td> </tr> </table> <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <th colspan="3" style="text-align: center;">FAULT CATEGORY</th> </tr> <tr> <td style="width: 33%;"> ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes </td> <td style="width: 33%;"> ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center </td> <td style="width: 33%;"> ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence </td> </tr> </table>	AGAINST DEPARTMENT/PROCESS				Mark _____ ap _____ -is _____ ed _____	Skid-tube _____ Machining _____ Thermoforming _____ Large Fab _____	Cross tube _____ Small Fab _____ Finishing _____ Composite _____	Water Jet _____ Prod. Eng. Coord. _____ Rec/Store/Packaging Supplier _____	Engineering _____ Quality _____ Other _____				QTY Effective : _____			MRB (QS1042) Approval _____	Disposition			Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____	FAULT CATEGORY			☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center	☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence
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